

Work Order ID: 77532

December-13-11 8:24:14 AM

77532

Page 1

Item ID: D4062-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Tank Support

Start Date: 12/13/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4062

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4062-1_BLANK

B12-1-5



102

QC2- Inspect parts off machine FAI/FAIB

0.00

102

QC

Memo

0.00

Quality Control

B12-1-5

105

0.00

105

Mill Conv

Memo

0.00

Conventional Milling Machine

mill counter bores as per dwg

W
A
h

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Page 2

Item ID: D4062-1

Revision ID:

Item Name: Upper Tank Support

Start Date: 12/13/11 Start Qty: 1.00

Required Date: 12/14/11 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

106

106

QC

Quality Control

QC2- Inspect parts off machine FA FAIB

0.00

Memo

0.00

130

130

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

140

140

Packaging

Packaging

Identify as per dwg & Stock Location: RAT 2-

0.00

Memo

0.00

JIG ONLY
change to 02638 DE

Work Order ID 77532

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Item ID: D4062-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Tank Support

Start Date: 12/13/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/20/11

Picklist Print

December-13-11 8:24:14 AM

Page 1
T

Work Order ID: 77532

Parent Item: D4062-1

Start Date: 12/13/11

Required Date: 12/14/11

Parent Item Name: Upper Tank Support

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD
11-23 JLM VERIFIED BY:DD
IPP REV:B AS PER REV B 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	324.1443	3.6	3.6			

B12-1-5

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	324.1443158	
117321	74.6	
117738	96.3	
117819	83.3	
118814	1.5	
119145	68.4443158	

119145

①

Work Order: 77532

Part Number: D4062-1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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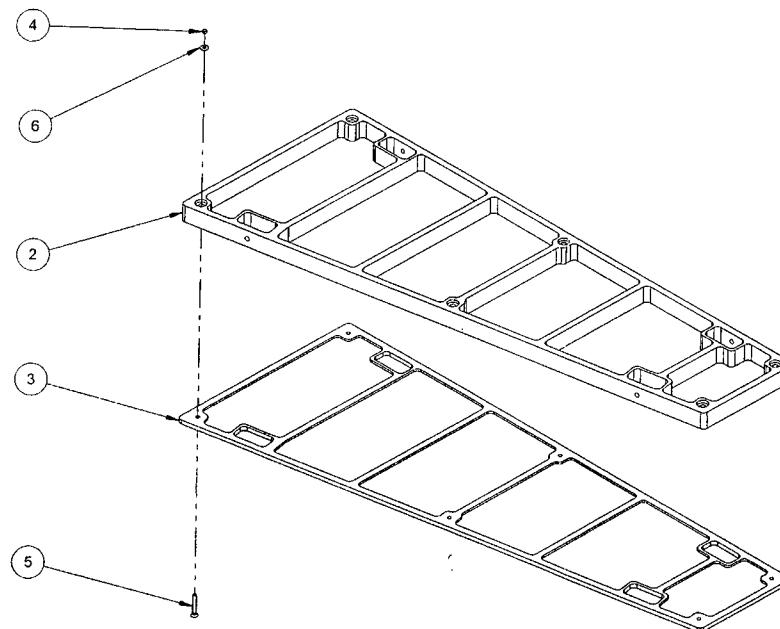
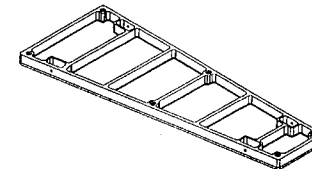
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.68	$\pm .030$.666	✓		V ABC 2	
3.07	$\pm .030$	3.071	✓		V	
5.07	$\pm .030$	5.081	✓		V	
15.69	$\pm .030$	15.69	✓		T B01	
26.30	$\pm .030$	26.30	✓		T	
28.30	$\pm .030$	28.30	✓		T	
30.70	$\pm .030$	30.70	✓		T	
31.38	$\pm .030$	31.38	✓		T	
.38	$\pm .030$.396	✓		V	
.68	$\pm .030$.671	✓		V	
1.38	$\pm .030$	1.385	✓		V	
5.72	$\pm .030$	5.743	✓		V	
6.29	$\pm .030$	6.29	✓		T	
8.44	$\pm .030$	8.44	✓		T	
11.17	$\pm .030$	11.17	✓		T	
11.98	$\pm .030$	11.98	✓		T	
1.00	$\pm .030$	1.010	✓		V	
1.00	$\pm .030$	1.001	✓		V	
2.00	$\pm .030$	2.001	✓		V	
.35	$\pm .030$.348	✓		V	

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	UPPER TANK SUPPORT
3	1	D4062-3	LOWER TANK SUPPORT
4	6	MS21042L08	NUT
5	6	MS24694-S62	SCREW
6	6	NAS1149D0332J	WASHER



W677532

D4062-041 TANK SUPPORT ASSEMBLY

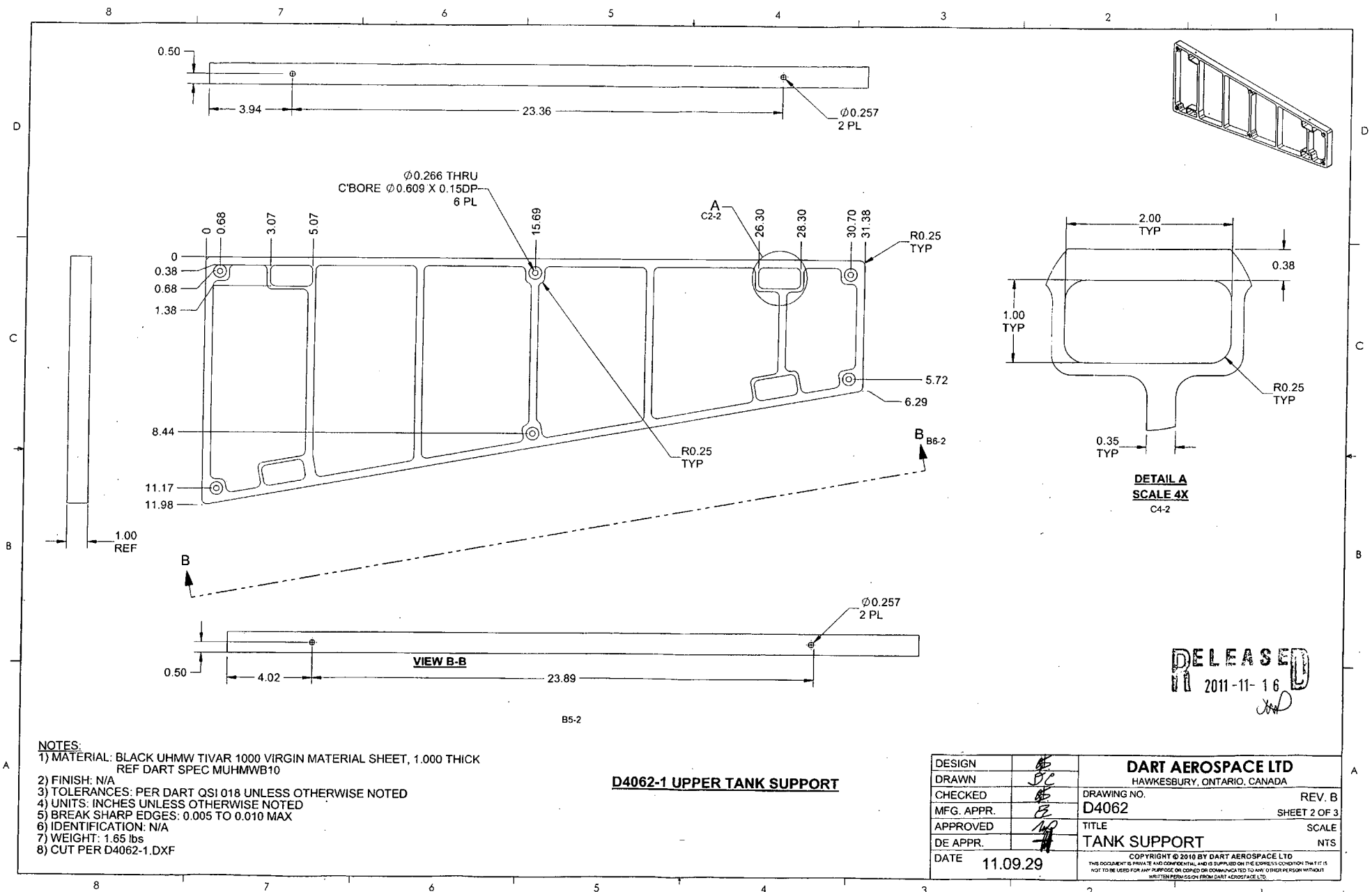
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.10 lbs

B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	11.09.29		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4062	REV. B
TITLE TANK SUPPORT	SHEET 1 OF 3
SCALE NTS	

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RELEASED
2011-11-16

